

ml



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5955
Job Sheet 193242

Part No: D5955

Job Qty: 5 pcs

Part Name: Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 4/26/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F ecn826 06.12.06 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	5 pcs	4/26/19		0.32	13.89	HAAS - 1		SBL / VHS 19/4/12
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	5 pcs	4/26/19		0.00	0.00	QC 2 - 1		VHS 19/4/12
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S171334



Part: D5955

Job No: 193242

Serial No/Batch: S171334

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/10/19

P.T.O.

120 QC 8	5 pcs	4/26/19	0.00	0.00	QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	from 12/04/12
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
130 Handfinish - 1-1 Chemical-B4B	5 pcs	4/26/19	0.00	0.43	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/04/15
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 -	

				B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 Powdercoat - 1 White Gl(A)- B4B	5 pcs	4/26/19	0.00 0.23	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
150 QC 3	5 pcs	4/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Plex 4/9/19 2:49 PM dart.lacelle.linda	

140 Powdercoat - 1 White Gl(A)- B4B 5 pcs 4/26/19 0.00 0.23

STAT: 12:55 O.T: 300° Finish: 1:25.

BL 19-06-15

DAS
40

APR 15 2019 8:00

				Packaging 3 - 27 - B4B	5+399	APR 16 2019
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
170	QC 21 - SA	5	4/26/19	0.00	0.00	
		pcs				
				QC 21 - SA - 21		
				QC 21 - SA - 70		APR 16 2019
				QC 21 - SA - 53		21
Part Op 100 - (HAAS CNC Vertical Machine), 1-Machine as per folio D5955,Ensure Batch Number is entered						
Descriptions: 110 - Inspect on CMM as per folio CMMA018.						
120 - (QC8- Inspect parts - second check)						
130 - (Chemical Conversion Coat per QSI005 4.1)						
140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: _____						
150 - (QC3- Inspect Part Finish)						
160 - (Identify as per dwg & Stock Location:_____)						
170 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D6101-013	Saddle Billet	5 pcs (1 ea)	100-HAAS 4 Axis	S111634 x6		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-HAAS 4 Axis	D6101-013	5	11	0		
Part Specifications						
Specifications could not be found.						

DART AEROSPACE LTD		Work Order:	193242
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.316	0.316	0.316	0.316		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.316	0.316	0.316	0.316		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.500	0.500	0.500	0.500		
N	1.865	1.885		1.877	1.877	1.877	1.877		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.3125	0.3125	0.312	0.312		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.505	0.505	0.503	0.503		
T	1.625	1.645		1.625	1.625	1.625	1.625		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: SBL/1/11/12	Audited by: J. Henry
Date: 19/04/12	Date: 19/04/12

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

DART AEROSPACE LTD		Work Order:	193242
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955		Rev: B	Page 1 of 1

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K	0.315	0.322		0.316					
L	0.495	0.505		0.500					
M	0.490	0.510		0.500					
N	1.865	1.885		1.877					
O	7.990	8.010		8.000					
P	2.240	2.260		2.250					
Q	0.307	0.312		0.310					
R	0.760	0.765		0.760					
S	0.490	0.510		0.503					
T	1.625	1.645		1.625					
U	2.000	2.020		2.000					
V	0.023	0.043		0.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	VHS	Audited by:	SM/16
Date:	18/04/12	Date:	19/04/12

Rev	Date	Change	Revised by	Approved
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F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

DQA: _____ Date: 19/4/11 *ml 20 Jun 2019*

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: <u>193242</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																																																			
Part No. <u>D5955</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐																																																																																																													
NCR No. <u>19-7214</u>		Suspected Unapproved ☐		QTY Effective: <u>1</u>																																																																																																																			
Date: <u>APR 12 2019</u>		Step #: <u>110-QC2</u>		MRB (QSI042) Approval <u>19-04-12</u>																																																																																																																			
Description Work Order Deviation				Disposition																																																																																																																			
Power surge cause the milling to machine into the saddle while doing the finish pass of the small bore.				- SCRAP and replace batch # <u>511634</u>																																																																																																																			
Root Cause				FAULT CATEGORY																																																																																																																			
<table border="1"><tr><td>Environment</td><td>☒</td><td>No Re-verification</td><td>☐</td></tr><tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr><tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr><tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr><tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr><tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr><tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr><tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr><tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr><tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr></table>				Environment	☒	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table border="1"><tr><td>Temperature/Cure</td><td>☐</td><td>Power Loss/Surge</td><td>☒</td><td>Positioned Wrong</td><td>☐</td></tr><tr><td>Set-up</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr><tr><td>BOM/Route</td><td>☐</td><td>Grain</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr><tr><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr><tr><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr><tr><td>Contamination</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr><tr><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td><td>Drawing</td><td>☐</td></tr><tr><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td><td>Finish</td><td>☐</td></tr><tr><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Misread</td><td>☐</td></tr><tr><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr></table>								Temperature/Cure	☐	Power Loss/Surge	☒	Positioned Wrong	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Countersink	☐	Off-set	☐	Drawing	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
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